

split

Date: Wednesday, 09/04/2008 9:18:29 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL-350 UPPER BULKHEAD
Job Number	: 38504 -1		
Estimate Number	: 13100		
P.O. Number	:	Part Number	: D36553
This Issue	: 09/04/2008 S.O. No. :	Drawing Number	: D3655 REV A
Prsht Rev.	: NC	Project Number	: 00204
First Issue	: 11 Type : THERMOFORMING	Drawing Revision	: A
Previous Run	: 37664	Material	:
Written By	:	Due Date	: 30/04/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>DD 08-4-09</u>		
Comment	: Est. Rev. A 07/12/13 DL verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 23.0000 sf(s)/Unit Total : 46.0000 sf(s)
GE PLASTICS LEXAN SHEET
batch: 107574

→ PTO

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

BB 08/04/09 x2

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3655-3 and Folio FTA 017 using tool DT 8985

Dwg. Rev. A-3655
Folio Rev. A

BB 08/04/09 x2

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 08/04/09 (x2)

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Drawing Name: PANEL-350 UPPER BULKHEAD

Job Number: 38504

Part Number: D36553

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



08/04/11 Dh
x2

Comment: SECOND CHECK

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



08/04/11 Dh
x2

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3655

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



08/04/11 Dh
x2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

RPP 39385

u

10.0

QC21

FINAL INSPECTION/W/O RELEASE



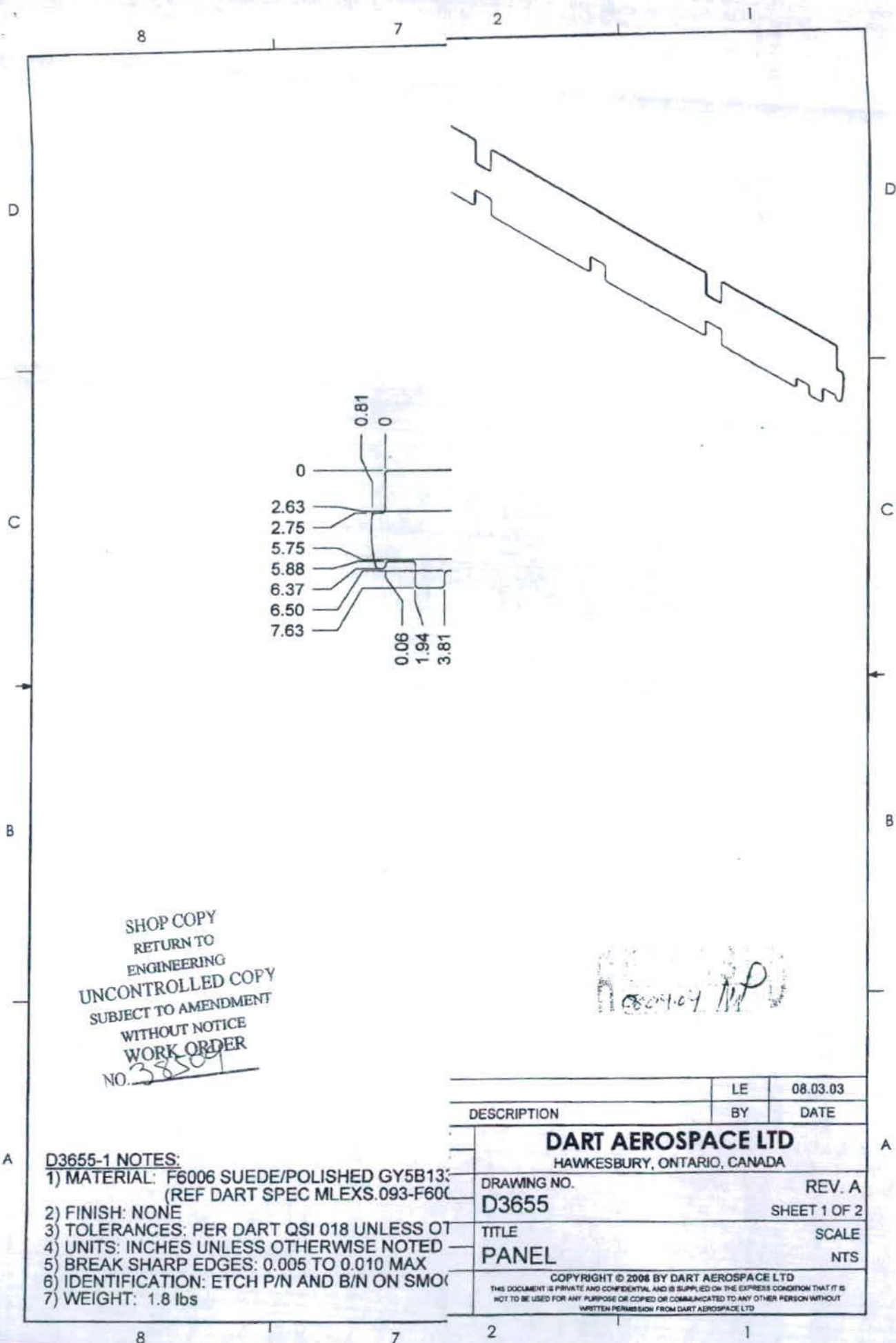
08/05/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/05/22



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 WITHOUT NOTICE
 WORK ORDER
 NO. 38509

Handwritten signature and date: 08-01-04 MP

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133
 (REF DART SPEC MLEXS.093-F6006)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOT
- 7) WEIGHT: 1.8 lbs

	LE	08.03.03
DESCRIPTION	BY	DATE
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO. D3655	REV. A SHEET 1 OF 2	
TITLE PANEL	SCALE NTS	
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DART AEROSPACE LTD		WORK ORDER: 38504
Description: Panel 350 UPPER Bulkhead		Part Number: D36553
Inspection Dwg: D3655 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Tight, even radius throughout part	DL-
Acceptable shape definition	DL-
Acceptable texture retention	DL-
Free of visual flaws (bumps, cracks, voids, etc.)	DL-

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D36553 Rev. A and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
45.5	±1	44.5		✓		E-MP: 10
19.9	±1	20.9		✓		E-MP: 10
.050	M.N.	.054	✓			ACCEPTED

Measured by: DL	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 08.04.10	Date: 08.04.10	Date: 08.04.10

Rev	Date	Change	Revised by	Approved
		New Issue		

[Signature]

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: April 11, 2008 3:31 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Leger, Daryl'; 'Bill Beckett'
Subject: FW: NCR D3655-3
Attachments: Image1.jpg; D3655-RevA.pdf

Mike/Daryl,

I'm not very happy about this to say the least. We just went through the exercise of making a set of parts, trimming them to templates, conforming them to the drawings, and installing them in an aircraft. How can we have been off by 1"? This is totally unacceptable in my opinion. Someone along the line has dropped the ball. How could we have conformed the parts if they were 1" different than the drawings?

My guess is that all fingers will be pointed to Leanne because she is no longer there to defend herself, but if the drawings were no good, then why did you both sign them???? This is the kind of stuff you should be checking. I cannot do this myself from Calgary.

Now we're going to spend more time and money updating Solidworks models and doing drawing updates. We just certified this. These types of issues should have been sorted out on conformity. That was the whole point.

Chris,

If the parts match what is in the aircraft, they will be acceptable. But I don't think we should make any more without doing a PROPER FAI and checking against the drawing.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Friday, April 11, 2008 7:41 AM
To: dshepherd@dartaero.com
Cc: mpetsche@dartaero.com; D Leger
Subject: NCR D3655-3

David,

For the D3655-3 Panel (350 interiors), the dwg dimension 19.9" is 20.9", dwg dimension 45.5" is 44.5". Ref attached pic. The part was made to the mold. The dwg was evidently created before the mold, and the dimensions were never updated.

The 20.9" width of the 'slot' fits with the mating part correctly; 19.9" would be too small and would have a sloppy fit. A verified this myself.

The dwg length of 45.5" is impossible to achieve from the mold. Daryl made the part as long as possible. The

2008-04-24

parts have evidently been fit into the aircraft and I'm told this dim works.

The dwg obviously needs an update. In the meantime, can we accept this deviation?

-Chris

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